

Date: Monday, 5/15/2006 10:42:41 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FOLDING STEP WELDMENT RH
 Job Number : 27087
 Estimate Number : 10697
 P.O. Number : NIA Part Number : D3388042
 This Issue : 5/15/2006 S.O. No. : NIA Drawing Number : D3388 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : LARGE FAB ASSY Drawing Revision : A
 Previous Run : 26653 Material : NIA
 Due Date : 5/30/2006 Qty: 5 Um: Each
 Written By : *See Comment Below*
 Checked & Approved By : *Ob. 05.15 W*
 Comment : Est. B 05.06.10 Added Step 11 KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 D2622-120C extrusion
 Batch: *324563*

PE 06.05.24 5

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
 CUT D2622-120C extrusion 85.15" long as per Dwg D3388

PE 06.05.24 5

Deburr and bevel ends for welding

PE 06.05.24 5

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
 206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<i>324402</i>

PE 06.05.24 5

4.0 D33872 Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Arm

Pick:

Qty	Part Number	Description	Batch
2	D3387-2	Arm	<i>325934 = 2 3 26671 = 2 3 27143 = 6</i>

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FOLDING STEP WELDMENT RH

Job Number: 27087

Part Number: D3388042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld arms and (1) end cap as per Dwg D3388.

Grind end cap welds flush

Dwg Rev: A

A/R AL ROD Batch: m19123 m15689

PE 06.05.26
FF 06.05.29

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06.05.29

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 06.05.30

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld last end cap as per Dwg D3388.

Inspect for foreign objects as per QSI 024.

Grind end cap welds flush

Dwg Rev: A

A/R AL ROD Batch: m15689

06.06.01 FF

PE 06.05.31

PE 06.05.31

PE 06.05.31

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06.06.02

Ja.06.03

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Chemical Conversion Coat as per QSI 005 4.1

FF 06.06.06

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

PL 06.06.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/28

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 5/15/2006 10:42:42 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FOLDING STEP WELDMENT RH

Job Number: 27087

Part Number: D3388042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3388 and QSI 005 4.4

FL 06 06 26 (5)

13.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

11/ 06 06 27 (5)

14.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Spacer

Pick:

Qty Part Number Description Batch

1 D2808

Spacer

B 26 648

Press spacer into D3387-2 arm as per Dwg D3387

SB 06/06/28 (5)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/06/28 (5)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CA

SB 06/06/28 (5)

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/28 (5)

Job Completion



U 06-06-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

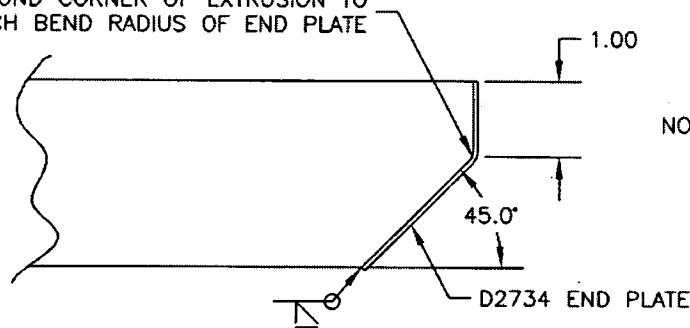
QA: N/C Closed: _____ Date: _____



RELEASED
05-03-11

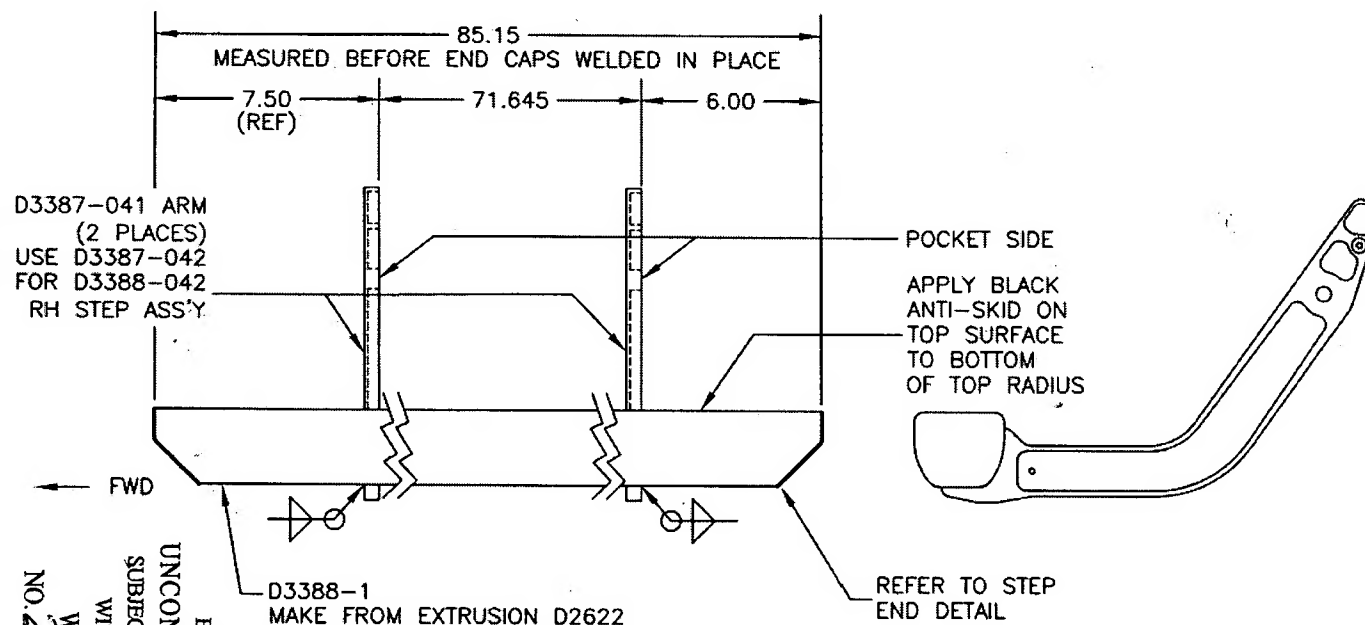
DESIGN	DRAWN BY	DART AEROSPACE LTD
05-01-20	05-01-20	NEW ISSUE
CHECKED	APPROVED	DRAWING NO.
05-01-20	05-01-20	D3388
DATE	TITLE	SHEET 1 OF 1
05-01-20	STEP WELDMENT	SCALE
A		NTS

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



NOTE: ALL WELDS SHALL BE 100%
VISUALLY INSPECTED BY A
QUALIFIED INSPECTOR PER
DART QSI 004

TYPICAL STEP END DETAIL
NOT TO SCALE



UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 21087

D3388-041 LH STEP ASSEMBLY (SHOWN)
D3388-042 RH STEP ASSEMBLY (OPPOSITE)

1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2) WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4